Dart Aerospace Ltd. Wednesday, 5/16/2007 7:57:22 AM Date User: **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : LATCH PLATE Customer Job Number : 32355 **Estimate Number** : 10511 P.O. Number : NIA **Part Number** : D2621 : D2621 REV. B S.O. No. : NIA : 5/16/2007 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : SMALL /MED FAB First Issue **Drawing Revision** :NA : 31111 **Material** Previous Run : 5/22/2007 Each **Due Date** 30 Um: Written By Checked & Approved By : Est: C \cdot 02.02.28 Added inspection level 8 and level 5 SM Comment Additional Product Job Number: Seq. #: Machine Or Operation: Description: 5052-H32 .040 Sheet 1.0 M5052H32S040 Comment: Qty.: 1.9688 sf(s) 0.0656 sf(s)/Unit Total: Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2621 Dwg Rev: 13 Prog Rev:\_\_ ml07/06 07/06/13 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 07/06/13 4.0 SECOND CHECK Comment: SECOND CHECK

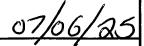
5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1





## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			-						
Part No	):	PAR #: Fault Category:	NCR: Yes	No DQ	A: 🗀	Date: _	07/04/09		

QA: N/C Closed: \_\_\_\_ Date: \_\_\_

CR: WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		Varification	Annroval	Annroyal
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
							,
	·						
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C Section A Action Description Sign & Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Chief Eng

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 7:57:22 AM \*User: Kim Johnston **Process Sheet** Drawing Name: LATCH PLATE Customer: CU-DAR001 Dart Helicopters Services Job Number: 32355 Part Number: D2621 Job Number: Seq. #: Description: Machine Or Operation: POWDER COATING POWDER COATING 6.0 M 102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 INSPECT POWDER COAT/CHEM 7.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOL 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE W 17-0628 Job Completion

## **Dart Aerospace Ltd**

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

Part No: _	PAR #:	Fault Category:	NCR: Yes No DQA: _	Date:
			QA: N/C Closed: _	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		Verification	Approval	Annewal
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
					-		
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C	STEP Description of NC Section A Section B Initial Action Description Sign & Verification Section C Chief Eng

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>3</i> 23 <i>5</i> 5
Description: Latch Plate	Part Number:	D2621
Inspection Dwg: D2621 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.130	+/-0.010	2.133	/		Vern	
0.310	+/-0.010	0.313			Vern	
3.380	+/-0.010	3.387			Vern	
R0.250	+/-0.010	KD.250	/		R-6	
0.984	+/-0.010	0.984			Vern	
0.573	+/-0.010	0.575	1		Vern	
4.000	+/-0.010	4.008			Vern	
R0.125	+/-0.010	RO.125	<b>✓</b>		R-6	
0.040	4-0.010	0.039			Veru	
				,		

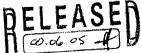
Measured by:	540	Audited by:	En	Prototype Approval:	N/A
Date:	02/06/13	Date:	07/06/18	Date:	N/A

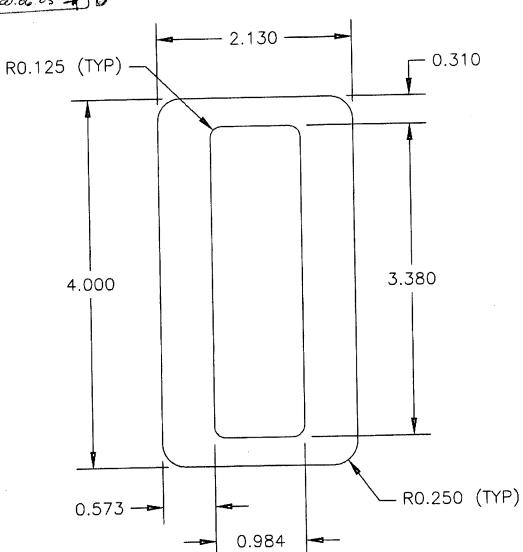
Rev	Date	Change	Revised by	Approyed
Α	04.06.15	New Issue	KJ/JLM	Cidl





DESIGN	<del>√</del> 3W	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(FD	APPROVED	DRAWING NO. REV. B
C/ILC/	#	#	D2621 SHEET 1 OF 1
DATE			TITLE SCALE
00.0	6.01		LATCH PLATE 1:1
 Α		96.08.15	NEW ISSUE
R		00.06.01	ADDED FINISH; R0.125 WAS R0.118





SHOP COPY

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024нтото

(QQ-A-250/4) 0.040 THICK

ENGINEERING

FINISH: CHÈMICAL CONVERSION COAT PER DART 005 4.1

POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

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